

Date: Thursday, 26/06/2008 9:12:29 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	X-TUBE AS 350/355 HI FWD
<b>Job Number</b> :	40102	<b>Part Number</b> :	D350748141TRN
<b>Estimate Number</b> :	13224	<b>Drawing Number</b> :	D350-748-141 REV D
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	26/06/2008	<b>Drawing Revision</b> :	D
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	/ /	<b>Due Date</b> :	07/07/2008
<b>Previous Run</b> :	40100	<b>Qty:</b>	1 Um: Each
<b>Written By</b> :			
<b>Checked &amp; Approved By</b> :	JLD 08.06.26		
<b>Comment</b> :	Est Rev:A New Issue 08-03-06 DD verified by:ec Est Rev B Removed polish 08.04.02 EC verified by : DD Est Rev C Remove LPS-3 08.06.23 EC verified by DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6017115	Crosstube Material
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Crosstube Material  
 D6017-115  
 2.339" OD X 2.000" ID  
 Batch: 327471

A.M 08.07.21 ①

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3- File transition lines smooth.

A.M 08.07.21 ①

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------

**Comment:** INSPECT ALL DIM TO DIM SHEET

A.M 08.07.21 ①

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA648

2- File transition lines smooth.

A.M 08.07.21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 26/06/2008 9:12:29 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD

Job Number: 40102

Part Number: D350748141TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Scribe Part & Batch as per Dwg D350-748-141

Q.m 08.07.21 (1)

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

Q.m 08.07.21 (1)

6.0

QC8

SECOND CHECK



AWM 8-7-21



Comment: SECOND CHECK

(P70)

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7262

Heat Treat to min 180 KSI As per Dwg D350-748-141

(MIL-T-6736 OR AMS 2759-1C)

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

C208109/29 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

POSITIVE  
RECALL

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Soslu'8 (x)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Oil inside of tube with LPS-3.

A/R LPS-3 Batch:

1/4 Soslu'8

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock in kanban rack

Location: \_\_\_\_\_


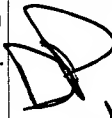

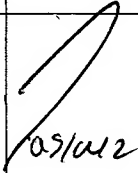
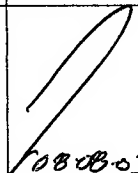

use for Bend  
Development only Soslu'8

POSITIVE  
RECALL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-141TRN PAR #: N/A Fault Category: Prod - x tube NCR: Yes No DQA: LA Date: 08.11.20  
Scrap / Scrap QA: N/C Closed: LA Date: 08/11/20

NCR: 40102		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080807	6-0	Tube was found to have a deviation (kink) in the surface of the material 40.125" up from the end of the tube.		use for bend development to w/o 002334	 8-11-19			
		R.C: Manufacturing defects from supplier. Appearing to be a chunk that pulled against and came out when the material was extruded from the die.						

NOTE: Date & initial all entries

Date: Thursday, 26/06/2008 9:12:30 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD

Job Number: 40102

Part Number: D350748141TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CHARGE TO W/O 00233A

MF 08-11-19

POSITIVE RECALL

EFFECTIVE 08-11-18 AUTH [Signature]

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 40102
<b>Description:</b> Crosstube Assembly (AS350/355 High Fwd)		<b>Part Number:</b> D350-748-141
<b>Inspection Dwg:</b> D350-748-141 <b>Rev:</b> D		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.237	+0.005/-0.000	2.242	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.306	+0.005/-0.000	2.311	✓			
	2.339	+0.005/-0.000	2.343	✓			
	2.339	+0.005/-0.000	2.343	✓			
	0.062	+/-0.010	0.062	✓			
	4.26	+/-0.030	4.260	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.50	+/-0.030	R0.500	✓			
SIDE B	2.240	+0.005/-0.000	2.245	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.180	+0.005/-0.000	2.185	✓			
	2.237	+0.005/-0.000	2.242	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.306	+0.005/-0.000	2.311	✓			
	2.339	+0.005/-0.000	2.343	✓			
	2.339	+0.005/-0.000	2.343	✓			
	0.062	+/-0.010	0.062	✓			
	4.26	+/-0.030	4.260	✓			
	R0.063	+/-0.010	R0.063	✓			
	R0.50	+/-0.030	R0.500	✓			
	110.27	+/-0.060	110.330	✓			

<b>Measured by:</b> am	<b>Audited by:</b> AWM	<b>Prototype Approval:</b> N/A
<b>Date:</b> 08.07.21	<b>Date:</b> 8-7-21	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	



DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED

06.10.31 *[Signature]*

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125  
FINISHED LENGTH =  $110.27 \pm 0.06$
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR  $\varnothing 0.297$  HOLE.

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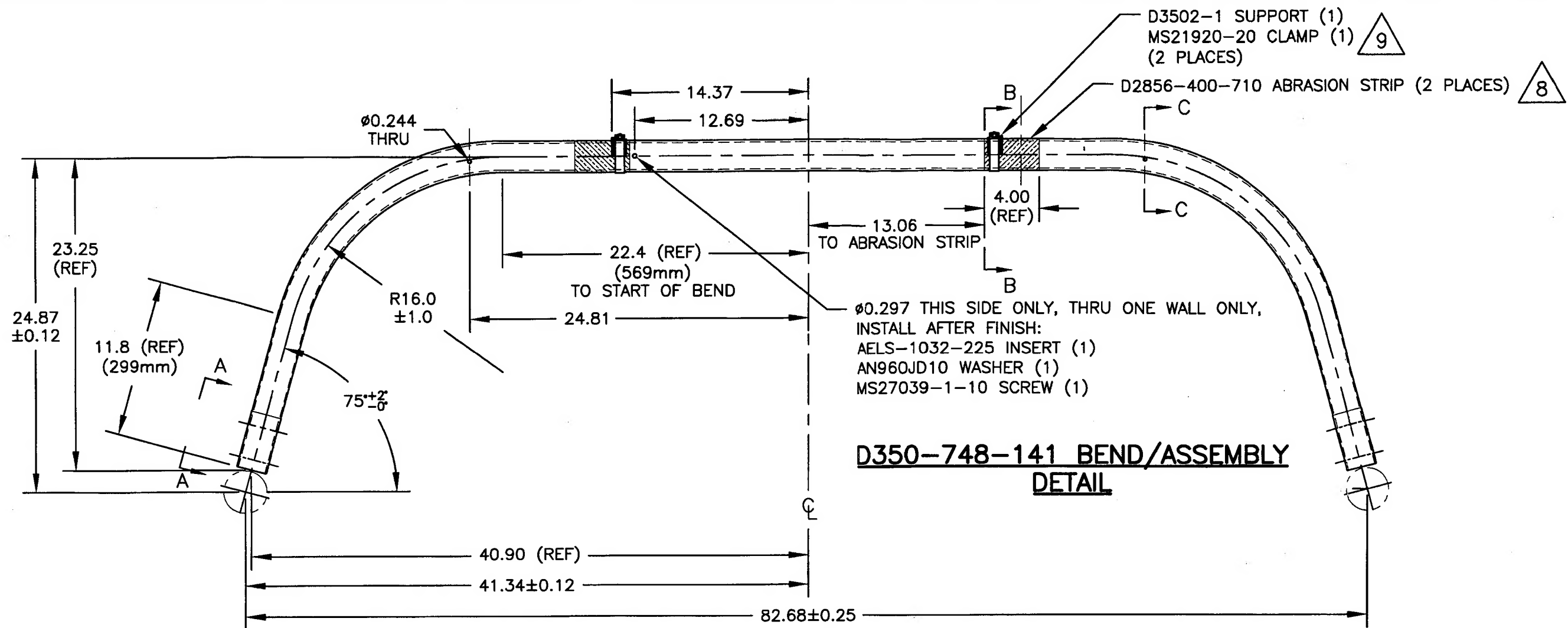
07.02/16 *[Signature]*

COPY SENT TO  
OK 07.10.22

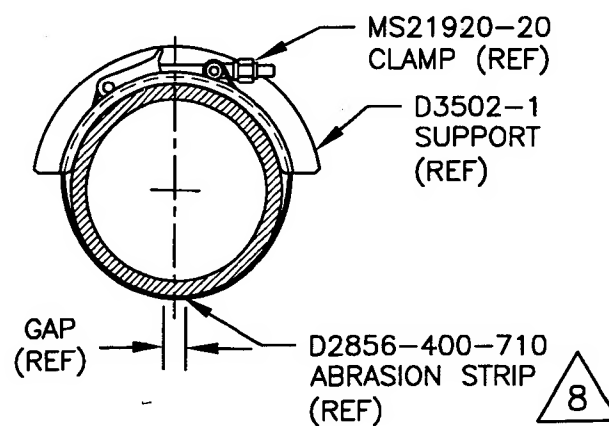
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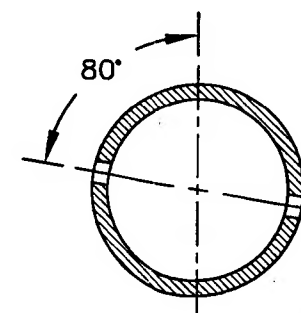




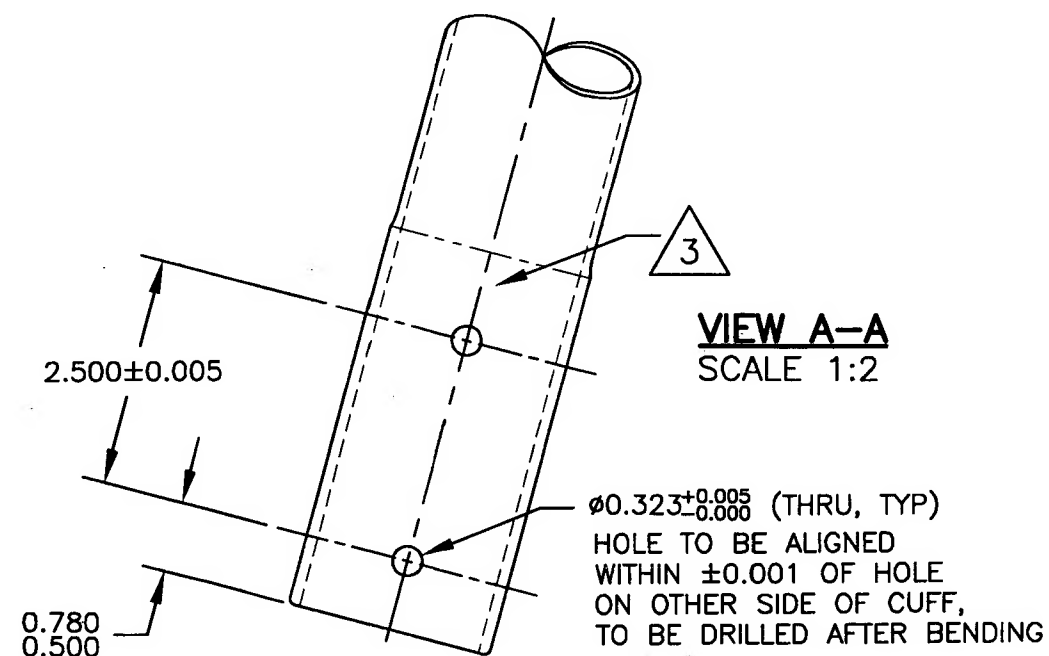
**SECTION B-B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2



**VIEW A-A**  
SCALE 1:2



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CUFF JENK REDUCED  
OK 07.11.22

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DESIGN

90

DRAWN BY

90

**DART**

**DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA

CHECKED

11

APPROVED

11

DRAWING NO.  
D350-748-141

REV. 0

DATE

06.10.31

TITLE

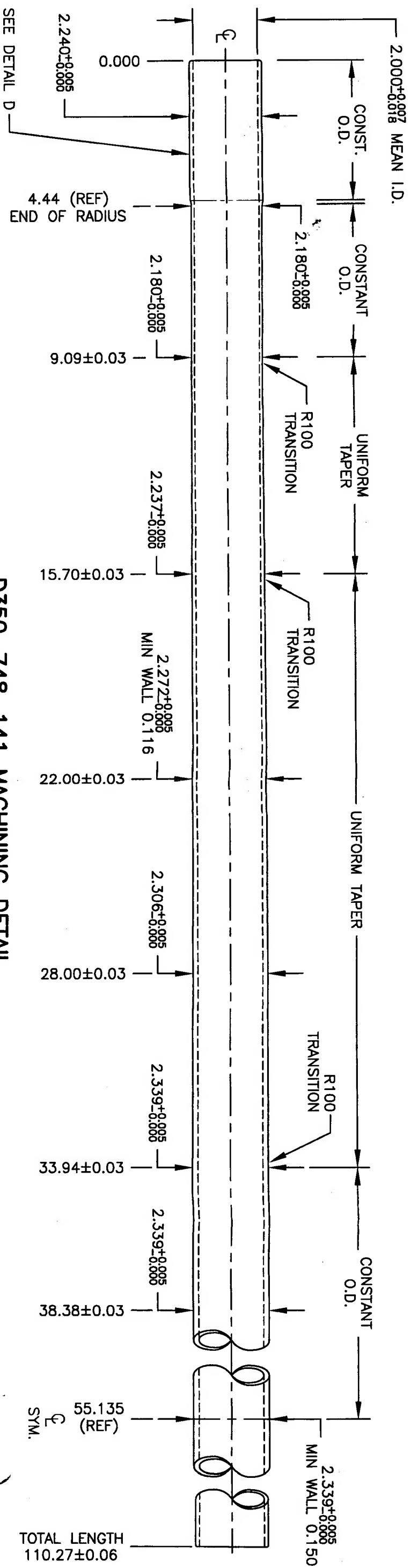
CROSSTUBE (AS 350/355 HI FWD)

SCALE

1:8

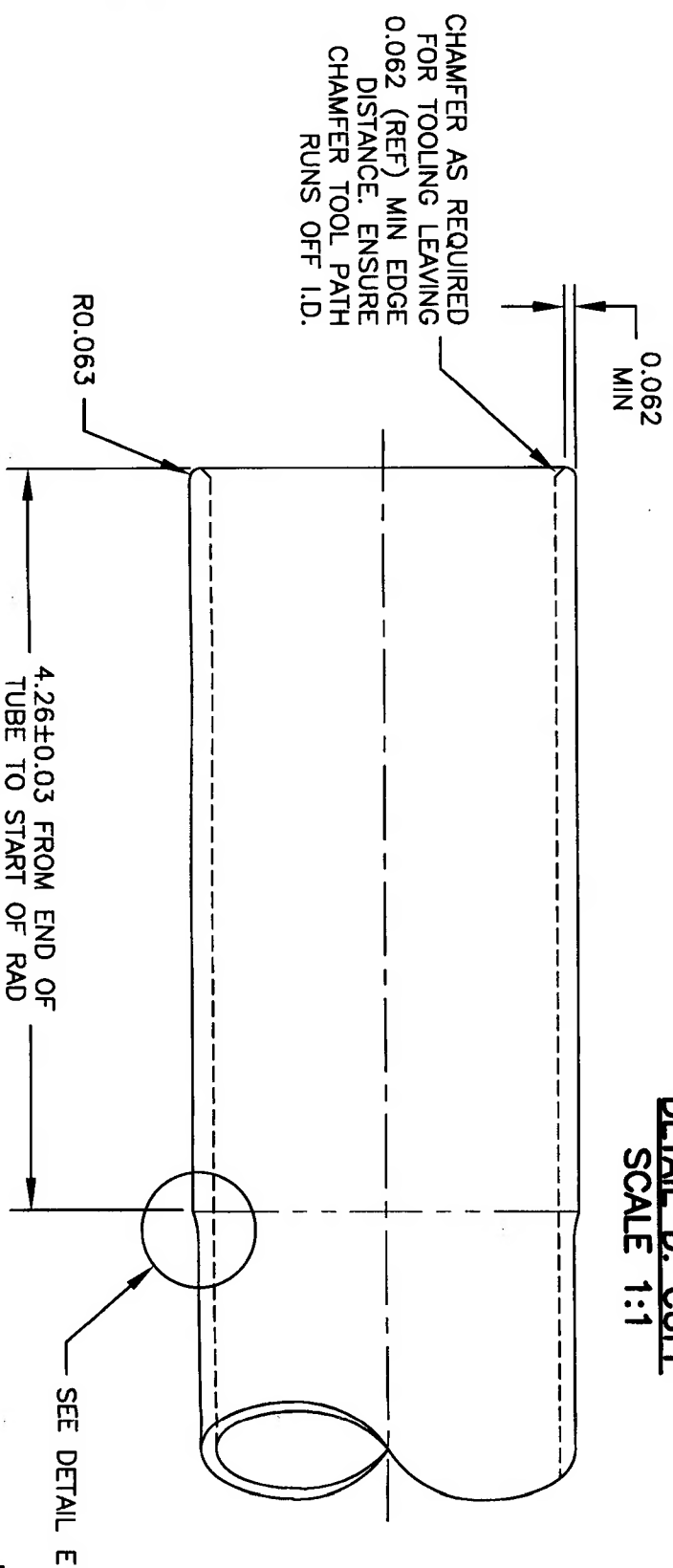
SHEET 2 OF 3



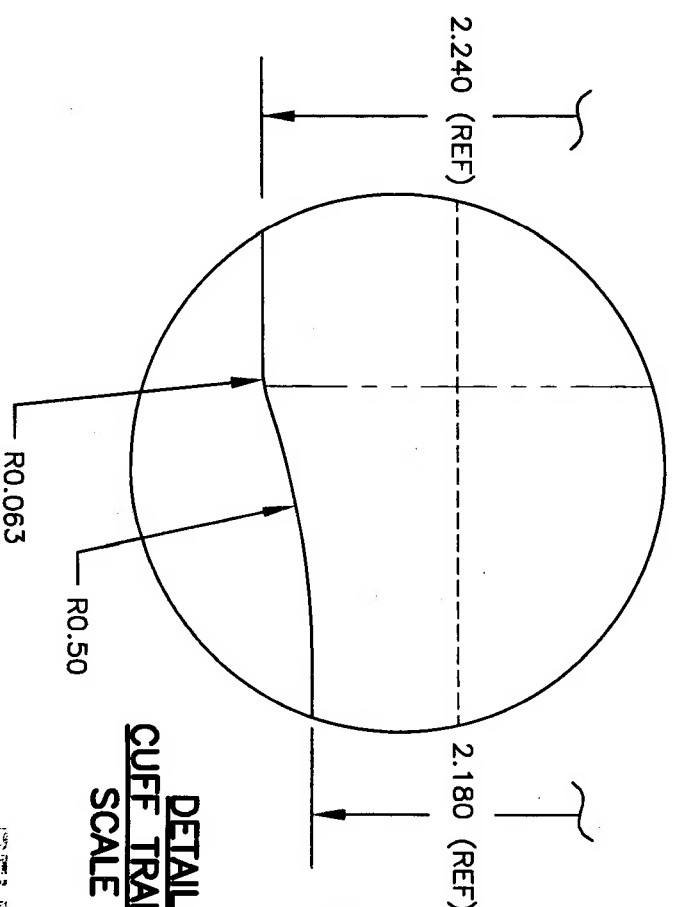


### D350-748-141 MACHINING DETAIL

#### DETAIL D: CUFF SCALE 1:1



#### DETAIL E: CUFF TRANSITION SCALE 9:1



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07.02/16/17  
DART Aerospace Ltd.  
06.10.31

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DESIGN	qj	DRAWN BY	qj
CHECKED	[Signature]	APPROVED	[Signature]
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI FWD)
DART AEROSPACE LTD.		DART AEROSPACE LTD.	
HAMILTON, ONTARIO, CANADA		HAMILTON, ONTARIO, CANADA	
DRAWING NO.	D350-748-141	REV. D	3 OF 3
SCALE	1:3		





**VAC AERO**  
INTERNATIONAL INC.

**RELEASE NOTE**

GST No. : R105468102

OAK 103192-4



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6I 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

11/14/2008

MM / DD / YYYY

PAGE : 1

1DAR01

BILL TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/14/2008		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
00007262/ 7409		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141 / -241	EA	11	11	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1D 100% HARDNESS TESTED AS PER ASTM E-18: 40-45 HRC GRIT BLASTED MATERIAL: 4130</p> <p>PO# PO00007262 4 PIECES D350-748-141: B40419, B40418, B40102, B40420 3 PIECES D350-748-241: B40110, B40413, B40414</p> <p>PO# PO00007409 4 PIECES D350-748-241: B42482, B42483, B42484, B42485</p> <p>NOTE: UNABLE TO FIND SERIAL NUMBERS ON PARTS</p>					

**100% HARDNESS TESTED**

11 pco.

41/42 HRC



S  
solukg

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

*Sandra Lyman*  
Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS

